

Work Order ID 144895

April 27, 2016 8:02:28 AM

144895

Page 1

Item ID: D4918-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Wearplate Center Fwd
 Start Date: 4/28/2016 Start Qty: 12.00 ***12*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 12.00 ***12*** Customer:
 Reference:

Approvals: Process Plan: SLA Date: 0160427 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D4918	A								
100	FLOW WATER JET	0.00							
100									
Waterjet	Memo	1.80							
FLOW CNC Waterjet	1-Cut as per Dwg Dwg Rev: <u>A</u> Prog Rev: <u>A</u> 2-Deburr if necessary								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.12							
Quality Control									

15 De 16/04/25

15 De 16/04/25

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
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LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				

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Stop ***NR2***

DAS
38
9-89
APR 29 2016

MAY 02 2016

DAS
38
289
MAY 02 2016

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 <i>WY130746</i> Memo START TIME: <u>7:45</u> OVEN TEMPERATURE: <u>320°</u> FINISH TIME: <u>8:15</u>	0.00 0.36				<u>15</u>	<u>0</u>	<u>1605-12</u>	<u>338</u>
160 *160* QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.12				<u>15</u>			DAS 38 9-89 MAY 12 2016
164 *164* HandFinish Hand Finishing	 Memo Coat entire top concave surface with Rockguard as per dwg and QSI A/R Rockguard: <u>134681</u>	0.00 2.88				<u>15</u>			DAS 41 9-89 16-5-12

DQA: _____ Date: _____



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166 *166* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.24				<u>15</u>			38 9-89
170 *170* Packaging Packaging	Identify as per dwg & Stock Location <u>FP-002</u> Memo LOCATION : FP002	0.00 0.12							
180 *180* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 1.20							

MAY 16 2016

X15 of 20 166051K

MCS MAY 17 2016

MCS MAY 16 2016

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				OTHER : ☐																																																																					

Picklist Print

April 27, 2016 8:02:32 AM

Page 1

Work Order ID: 144895

144895

Parent Item: D4918-3

D4918-3

Parent Item Name: Wearplate Center Fwd

Start Date: 4/28/2016

Required Date: 5/6/2016

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP REV:A 13.12.09 NEW ISSUE DD VERF:JFS

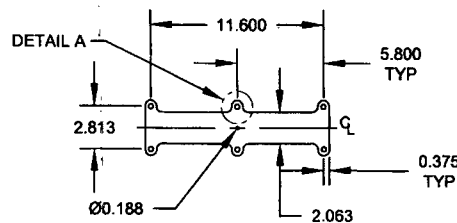
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	133.2210	0.774	9.776842			

M304S20GA

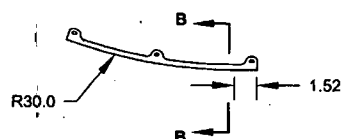
304/316 .040 Sheet

DC 16/04/28

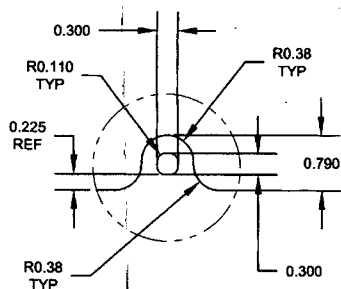
Location	Loc Qty	Loc Code
MAT020	130	
m134067	31.8	
m134399	34.2	12.5
m134495	64	
MAT20	3.221	
m133901	3.221	



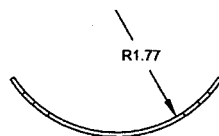
D4918-1F FLAT PATTERN



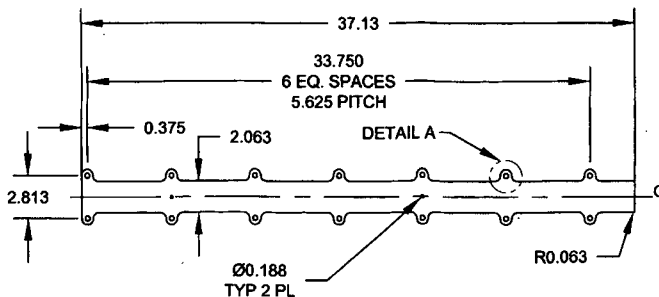
D4918-1 BENDING DETAIL
(MAKE FROM D4918-1F)



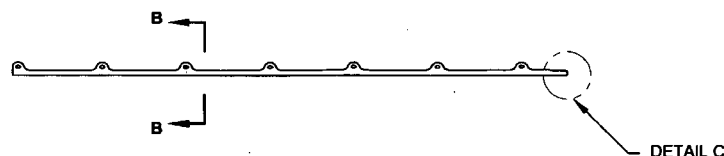
DETAIL A
(SCALE 4X)



SECTION B-B
(SCALE 4X)

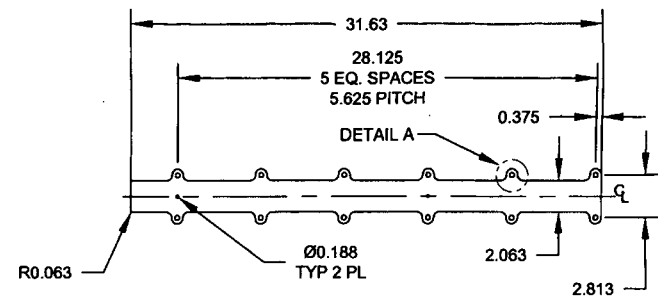


D4918-3F FLAT PATTERN

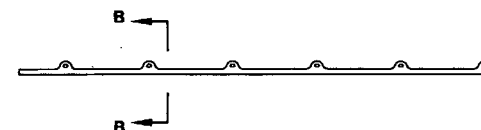


D4918-3 BENDING DETAIL
(MAKE FROM D4918-3F)

DETAIL C
(SCALE 4X)



D4918-5F FLAT PATTERN



D4918-5 BENDING DETAIL
(MAKE FROM D4918-5F)

NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: D4918-1 - 0.47 lbs, D4918-3 - 0.95 lbs, D4918-5 - 0.77 lbs,
- 8) COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

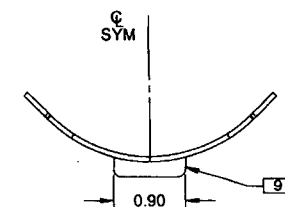
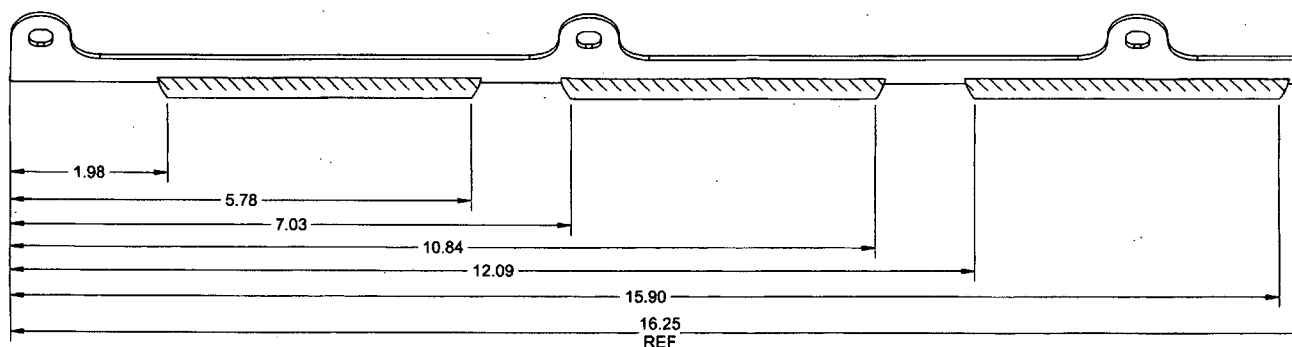
RELEASED
2013-12-10

REV.	DESCRIPTION	DW	13.08.30
DESIGN	DW	DATE	
DRAWN	DW	DATE	
CHECKED	CP	DATE	
MFG. APPR.	JP	DATE	
APPROVED	JP	DATE	
DE APPR.	JP	DATE	
DATE	13.08.30	DATE	

DART AEROSPACE USA, INC
KENT, WA
DRAWING NO. D4918
REVISIONS
SHEET 1 OF 3
SCALE
NTS
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20160427
SA
144895

ITEM	QTY	P/N	DESCRIPTION
1	X	D4918-047	WEARPLATE
2	1	D4918-7	WEARPLATE
3	A/R	2059B	HARDCOAT



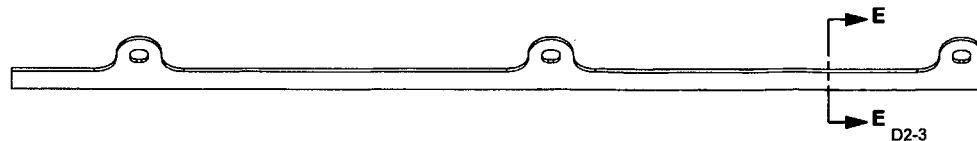
D4918-047 WEARPLATE

NOTES:

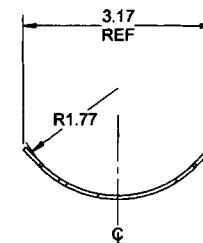
- 1) MATERIAL: PER PARTS LIST
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4918-047" PER QSI 044 6.1
- 7) WEIGHT: 2.18 lbs
- 8) WELD PER QSI 004
- 9) APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.19 TO 0.25 THICK UNLESS OTHERWISE INDICATED
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH PLUS ONE ROCKGUARD 4714, 0.020-0.040 THK

RELEASED
2013-12-10
W

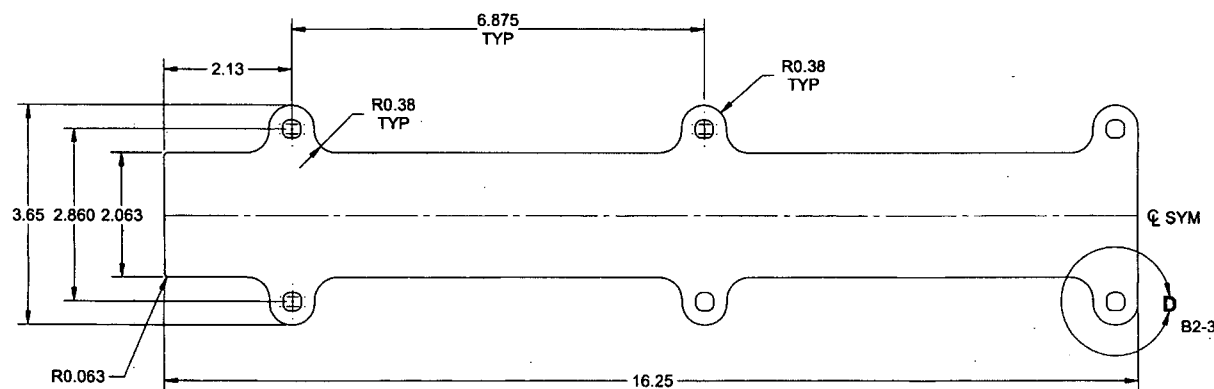
DESIGN	DW	DART AEROSPACE LTD	
DRAWN	DW	KENT, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	<i>[Signature]</i>	D4918	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	NTS
DATE	13.08.30	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



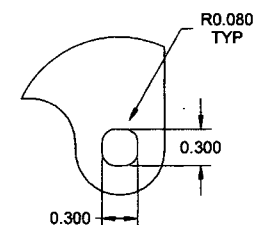
D4918-7 WEARPLATE
(MAKE FROM D4918-7F)



SECTION E-E
SCALE 2X D4-3



D4918-7F WEARPLATE
FLAT PATTERN



DETAIL D
SCALE 2X B4-3

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK), (REF. DART SPEC. M304S16GA)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.66 lbs

RELEASED
2013-12-13

DESIGN	DW	DART AEROSPACE LTD KENT, WA	
DRAWN	DW		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4918	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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